

Subject:	CHANGE IN FREQUENCY OF WET ADHESION TEST IN CASE OF AN AASS TEST RATING OF B, C OR D
Proposal:	Pretreatment WG (18.02.14)
QUALICOAT resolution:	<u>Resolution No. 10/TC 20.05.14</u> TC approved the Pretreatment WG's proposal No. 1/WG180214 to increase the frequency of the wet adhesion test from once to twice a week in case of a B, C or D rating in the AASS test and asked the Specifications WG to prepare a draft update sheet.
Date of ratification:	20 May 2015
Date of application:	1 January 2016
Amendments to the Specifications:	2.10. Acetic acid salt spray resistance <i>"Final assessment of the AASS test" table updated and improved</i> 6.3.4.2 Wet adhesion (<i>sentence added</i>) 6.5. Specifications for in-house control: <i>table summarising the specifications for In-House Control updated and improved</i>

2.10. Acetic acid salt spray resistance

[..]

Final assessment of the AASS test:

RATING	CORRECTIVE ACTION	
	APPROVAL (GRANTING/RENEWAL)	LICENCE (GRANTING/RENEWAL)
A satisfactory	No action	No action
B satisfactory	No action	<ul style="list-style-type: none"> ▶ The frequency of the wet adhesion test during in-house control shall be increased from once to twice a week for a period of three months.
C unsatisfactory	<ul style="list-style-type: none"> ▶ Repetition of the acetic acid salt spray resistance test. ▶ If the result of this second test is C or D, all tests shall be repeated. 	<ul style="list-style-type: none"> ▶ Repetition of the AASS test. If the result of this second test is C or D, the inspection shall be repeated. ▶ The frequency of the wet adhesion test during in-house control shall be increased from once to twice a week for a period of three months.
D unsatisfactory	<ul style="list-style-type: none"> ▶ All laboratory tests shall be repeated. 	<ul style="list-style-type: none"> ▶ The inspection shall be repeated (including an AASS test). ▶ The frequency of the wet adhesion test during in-house control shall be increased from once to twice a week for a period of three months.

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6.3.4.2 Wet adhesion

The wet adhesion test shall be carried out on ~~sample panels~~ finished products **at least once a week.**

The frequency of the test shall be changed to twice a week for a period of three months in case of an acetic acid salt spray test result of B, C or D (see 2.10. Final assessment of the AASS test).

The results shall be entered and retained on some record readily accessible to the inspector.

6.5 Table summarising the Specifications for In-House Control

CONTROL	OBJECT TESTED	MINIMUM FREQUENCY	RESULTS TO BE RECORDED IN	
Process	Chemical pre-treatment baths, degreasing, pickling, chromating, rinsing	Chem. Parameters	Once per day (24 hours) per bath	Chart or register
	Conductivity of the water		Once per day (24 hours)	Chart or register
	Temp. of chemical pretreatment and rinsing baths		Once per day (24 hours) per bath	Chart or register
	Drying temperature		Once per week	Chart or register
	Stoving conditions		Twice a day: record the displayed temperature Once a week: make 1 stoving curve on profiles	Chart or register
Conversion coating	Etching degree		Once per day (24 hours)	Chart or register
	Weight of the conversion coating (chromate conversion)		Once per day (24 hours)	Chart or register
	Weight of the conversion coating (chromium-free)		Following the chemical manufacturer's instructions (see Appendix A6)	Chart or register
Finished products	Gloss		Once in every 8-hour work shift for each shade and manufacturer	Chart or register
	Coating thickness		According to the lot size of the order	Chart or register
	Appearance		According to the lot size of the order	Chart or register
	Dry adhesion		Once in every 8-hour work shift for each colour shade and supplier	Chart or register
	Wet adhesion		Once a week (twice a week for 3 months in case of AASS test result B, C or D)	Chart or register
	Machu test		Once per week	Chart or register
Panels	Dry adhesion		Once in every 8-hour work shift for each shade and manufacturer	Chart or register
	Indentation		Once in every 8-hour work shift for each shade and manufacturer	Chart or register
	Polymerisation (optional for powder coatings)		Once in every 8-hour work shift for each shade and manufacturer	Chart or register
	Cupping test		Once in every 8-hour work shift for each shade and manufacturer	Chart or register
	Bend test		Once in every 8-hour work shift for each shade and manufacturer	Chart or register
	Impact test		Once in every 8-hour work shift for each shade and manufacturer	Chart or register